

Date: Friday, 9/7/2007 10:14:58 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PACKER
Job Number : 34466	
Estimate Number : 10225	
P.O. Number : <u>N/A</u>	Part Number : D2150
This Issue : 9/7/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2150 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 33884	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 9/14/2007 Qty: 20 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est C 00.11.27 Re-format (mpp 2101) EC	
Est Rev:D 06-08-23 Now on Waterjet JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.0263 sf(s)/Unit Total : 0.5250 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: M103321

SAO 07/09/09

7

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2150

Dwg Rev: AProg Rev: A

2-Deburr if necessary

SAO

07/09/09

20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAO

07/09/09

20

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SAO

07/09/10

count 20

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAO 07/09/10 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/09/17

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/7/2007 10:14:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PACKER

Job Number: 34466

Part Number: D2150

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Bl

07-09-13

(20)

7.0

POWDER COATING

POWDER COATING



ml 07 09 14



(20)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MS / M



07 09 14 (20)

Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5717

07/09/14

(20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

07/09/17

Job Completion



07/09/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34466
Description: Packer		Part Number:	D2150
Inspection Dwg: D2150 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.740	+/-0.010	0.739	✓		Vern	
2.050	+/-0.010	2.054	✓		Vern	
0.231	+/-0.010	0.234	✓		Vern	
1.217	+/-0.010	1.220	✓		Vern	
1.559	+/-0.010	1.560	✓		Vern	
2.300	+/-0.010	2.296	✓		Vern	
1.560	+/-0.010	1.559	✓		Vern	
0.250	+/-0.010	0.253	✓		Vern	
1.328	+/-0.010	1.331	✓		Vern	
0.342	+/-0.010	0.344	✓		Vern	
Ø0.098	+0.005/-0.000	Ø0.098	✓		Vern	
Ø0.171	+0.005/-0.000	Ø0.172	✓		Vern	
0.040	+/-0.010	0.040	✓		Vern	

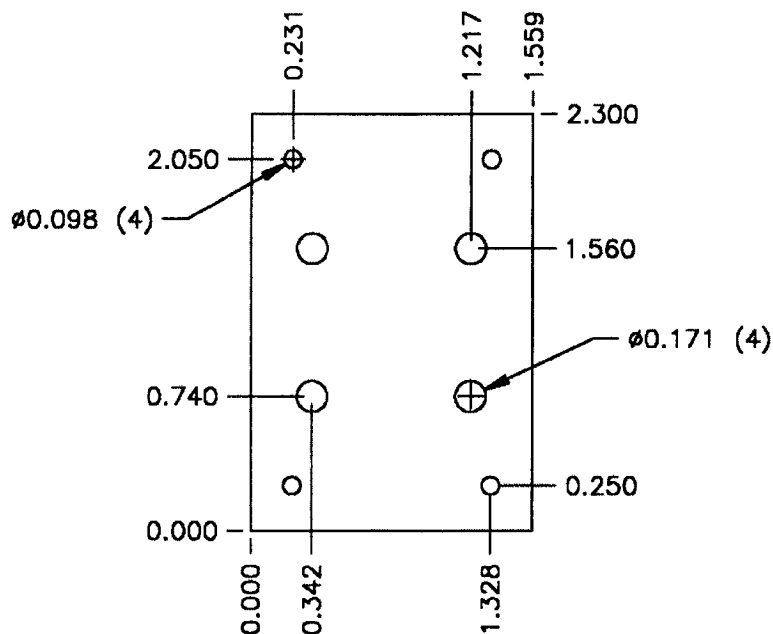
Measured by:	SAD	Audited by:	Er	Prototype Approval:	N/A
Date:	07/09/09	Date:	07/09/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.28	New Issue	KJ/JLM	[Signature]



DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2150	REV. A SHEET 1 OF 1
DATE 95:05:01		TITLE PACKER	SCALE 1:1

RELEASED
96/06/13 BW



MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34466

RECEIVED
JAN 10 1964
U.S. AIR FORCE
HEADQUARTERS
WASHINGTON, D.C.